

# Work Order ID 51171

August 6, 2009 9:20:49 AM



Page 1

Item ID: D3825-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Rib Assembly (Basket End)

Start Date: 8/06/09 Start Qty: 6.00

Cust Item ID:

Required Date: 8/07/09 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3825	Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3825-1 rib as per dwg D3825-1 2- drill hole (3/16") in D3825-1 using DT9438 jig and open to finish size as per dwg D3825-1 3- c'sink hole as per dwg D3825-1 4- remove identification markings 5- deburr

SAD 09-08-05 (6x)

SY 09/08/05 (6x)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> SC 09/08/07

(LC)

120

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- weld D2327-3 spacer bushing and D3759-1 bushing as per dwg D3825-1 A/R ER316 S.S. Rod Batch: 1109213 2- grind bushing weld flush where indicated on dwg D3825-1 3- deburr if necessary

SY 09/08/07 (6x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 51171

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Page 2

Item ID: D3825-041

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Setup Start



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Stop



Item Name: Rib Assembly (Basket End)

Start Date: 8/06/09 Start Qty: 6.00



Cust Item ID:

Required Date: 8/07/09 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00

PPC09-08-10



QC

Memo

0.00

Quality Control

140

QC5- Inspect part completeness to step on W/O

0.00

=> S 08/08/11



QC

Memo

0.00

Quality Control

(x6)

150

Identify as per dwg & Stock Location: Basket

0.00

PD 09-08-11



Packaging

Memo

0.00

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 51171

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Page 3

Item ID: D3825-041  
Revision ID: A  
Item Name: Rib Assembly (Basket End)

Accept

Setup Start

Stop

Start Date: 8/06/09 Start Qty: 6.00

Required Date: 8/07/09 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: Date:

QC: Date:

Tooling: Date:

SPC (Y/N): Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/08/18

u 9.8.26

# Picklist Print

August 6, 2009 9:20:48 AM

Page 1 / 1

Work Order ID: 51171

Parent Item: D3825-041RevA

Parent Item Name: Rib Assembly (Basket End)


Start Date: 8/06/09

Required Date: 8/07/09

Comments:


Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2327-3RevD  Spacer Bushing		Manufactured	No			100	Each	60.0000	6.0000			


<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Premier		
Mezz	60	
44274	51	
44365	9	

6x SM 09/08/07

D3759-1RevA  Bushing		Manufactured	No			100	Each	28.0000	6.0000			
--	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
WA	28	
50000	28	

2x SM 09/08/07

M304TS0.750W.065  304 SQ Tube .75x.75x.065W		Purchased	No			100	f	68.8315	13.4211			
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SAD 09-08-05 GP

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	68.83151369	
111148	0.484	
111432	0.44	
111885	1.5682	
112051	7.3691E-05	
112263	66.33924	

13.4211 q

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

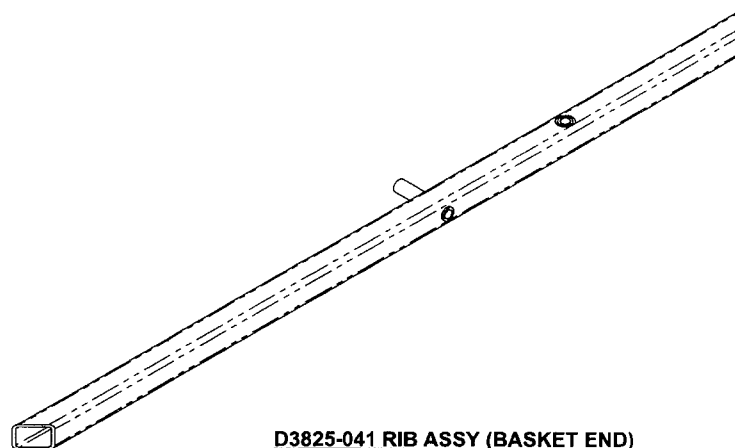
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3825-041	RIB ASSEMBLY (BASKET END)
2	1	D2327-3	SPACER BUSHING
3	1	D3759-1	BUSHING
4	1	D3825-1	RIB



**D3825-041 RIB ASSY (BASKET END)**

WB  
SUT 1

**RELEASED**  
09/11/18

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 1.22 lbs
  - 8) WELDING: PER DART QSI 004

A	NEW ISSUE	MB	08.09.23
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.23		

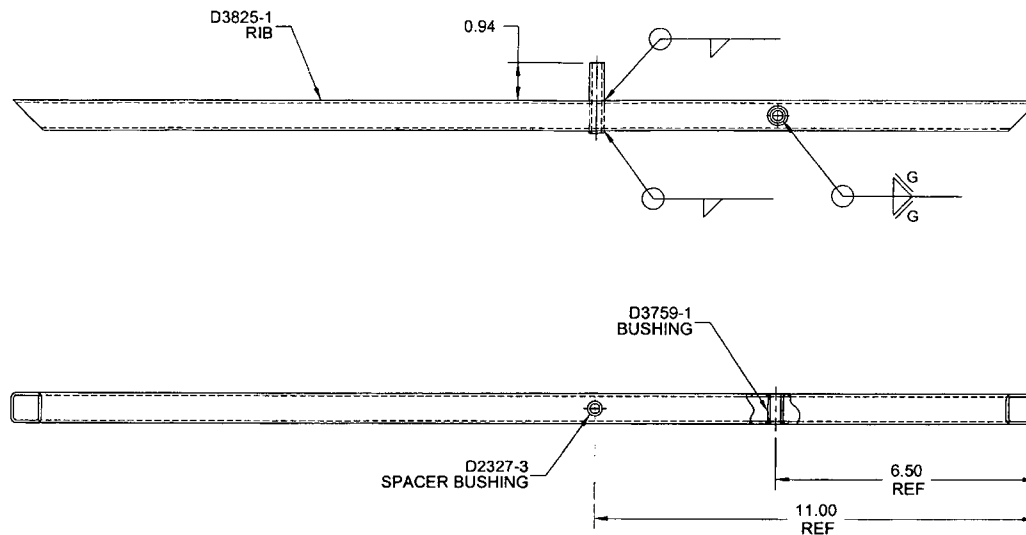
**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3825** REV. A  
SHEET 1 OF 3

TITLE **RIB ASSY (BASKET END)** SCALE NTS

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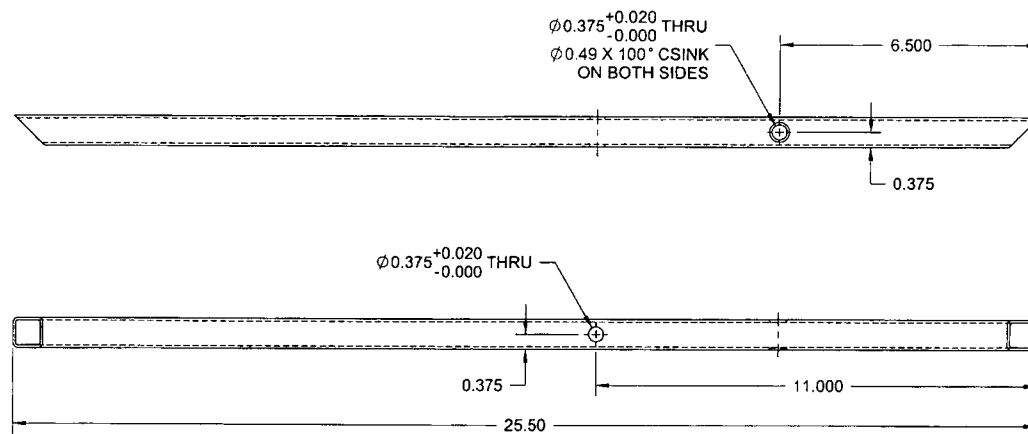
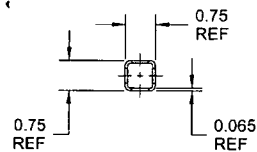


**D3825-041 RIB ASSY (BASKET END)**

51171

**RELEASED**  
08/11/18 NW

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. A
MFG. APPR.		D3825	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET END)	NTS
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**D3825-1 RIB**

51171

**RELEASED**  
08/11/18

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.18 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D3825</b>	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>RIB ASSY (BASKET END)</b>	NTS
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